

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019033**Date Inspected:** 28-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance(QA) Inspector Mr. Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. The QA Inspector observed and/or found the following:

BAY # 14

ULTRASONIC TESTING

ZPMC NWIT No: 07956

This QA Inspector performed Ultrasonic Testing (MT) of approximately 10% of the length previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an (UT) report on this date. The members are identified as OBG 13AE. The weld designations are as follows:

SEG3007AC-007, 008, 009

During the Ultrasonic testing of the weld SEG3007AC-009 this Quality Assurance (QA) Inspector discovered two class "A" non conforming indication measuring approximately 10 to 8mm in length, Material thickness is approximately 22mm. The depth of the indications was approximately 17 and 15mm respectively. The indication db rating was -5 and -1 respectively. The weld is Complete Joint Penetration (CJP) corner joint between BP3031 and SP3060B. Y locations of indications measured approximately 1720 and 1800mm respectively. For indication

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detail see the "UT" report as same date. Incident report was issued.

This QA Inspector randomly observed the following work in progress.

OBG 14 EAST

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 062782 performing the Flux Cored Arc Welding process on weld 179 located at PCMK SEG3019E-1. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044830 performing the Flux Cored Arc Welding process on weld 182 located at PCMK SEG3019E-1. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066443 performing the Shielded Metal Arc Welding process on weld 029 located at PCMK SEG3019AA. ZPMC QC Mr. Zhong Guo Hui was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-u4b-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 044824 performing the Flux Cored Arc Welding process on weld 323 located at PCMK SEG3019D-1. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

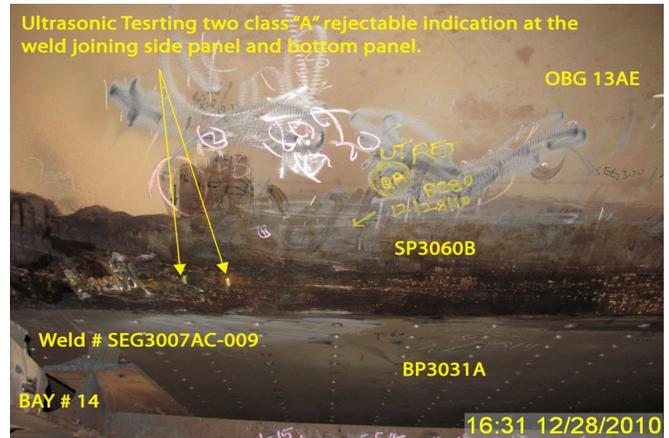
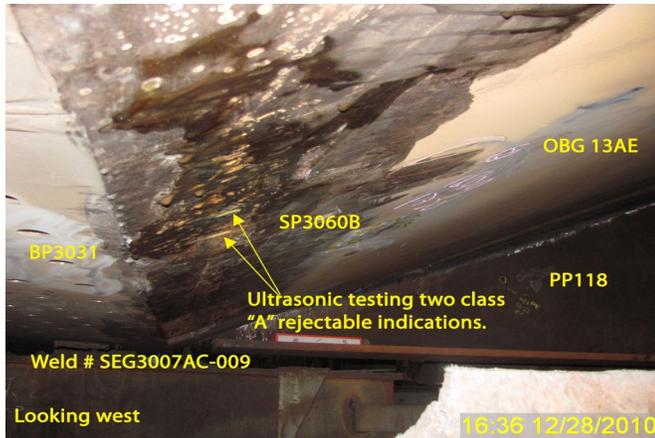
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 065501 performing the Flux Cored Arc Welding process on weld 002 located at PCMK SEG3019AA. ZPMC QC Mr. Xie Ming Feng was monitoring this welding operation. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

This Quality Assurance (QA) Inspector observed ZPMC personnel performed Ultrasonic testing for the weld joint between SA3325 and bottom panel. This QA Inspector observed ZPMC personnel mark approximately 35 rejectable indications for this weld. The length of weld measured approximately 4000mm. Weld number identified as SEG3019K-013.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer
